

Work Order ID 105498

105498

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August-07-13 1:19:45 PM

Item ID: D2702-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg Clevis
 Start Date: 8/07/13 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 8/09/13 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2702	Rev B								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 14.63" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Machine per folio D2702-2Tumble and deburr any rough edges after tumbling								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

DR 1 H.O
13/08/07
3 *Ø*

mf/MH *13/08/08*

mf/MH *13/08/08*

710 →
Last Page

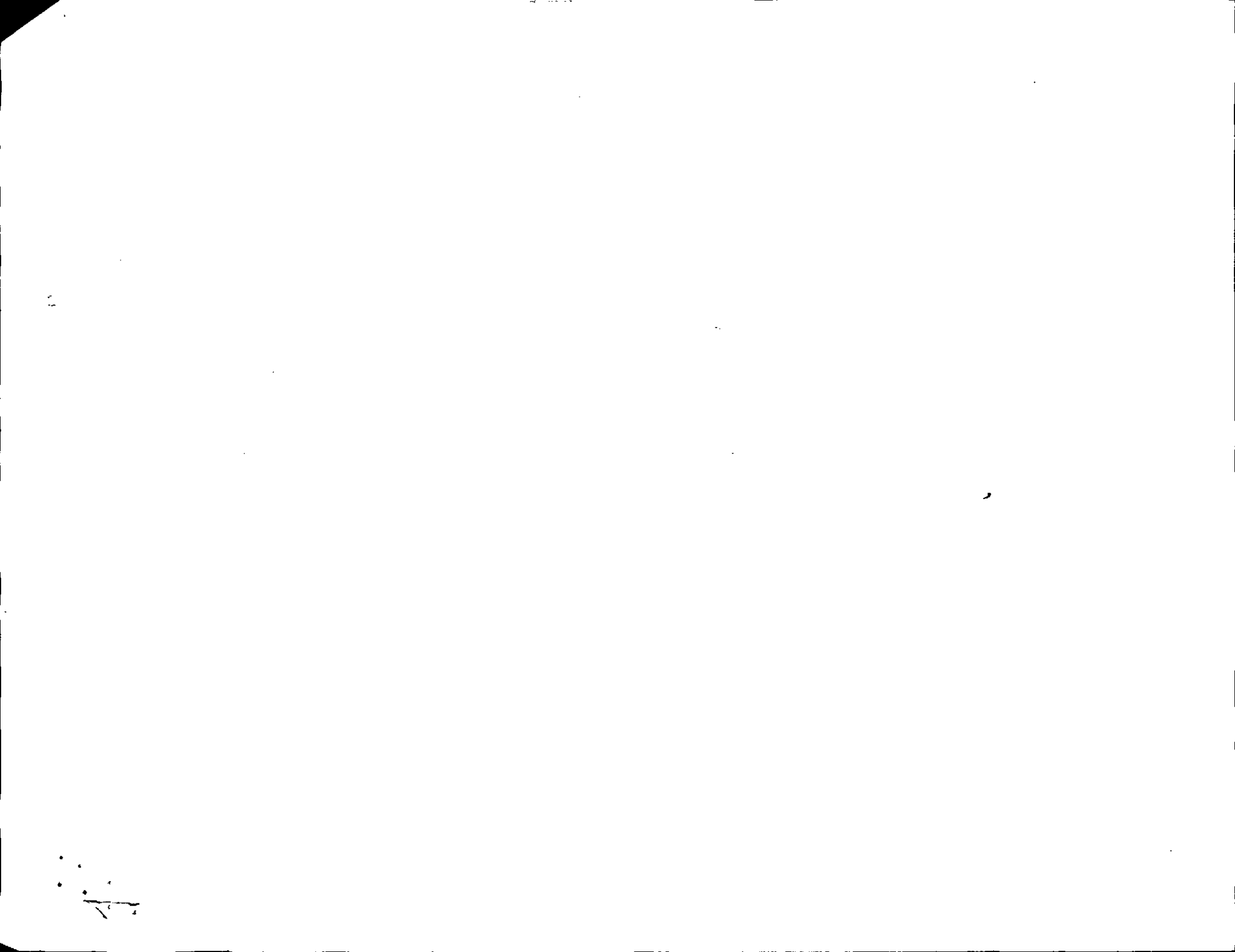
Jul/13-08-09
QCB. Second Check.

[Signature]

13-08-09

3

2936
1 + 4
1 + 4



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Item ID: D2702-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Leg Clevis

Start Date: 8/07/13

Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/09/13

Req'd Qty: 3.00

3

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

3

DAS
105
8-07-13

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

3X M-1 13/08/14

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320°F

9:00

3X M-1 13/08/14

W126125

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>8T230</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

3x 4 M 13/08/10

3x 8P 13-8-15

13/8/20 J
 MLC 13-08-15

Picklist Print

August-07-13 1:19:45 PM

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Work Order ID: 105498

Parent Item: D2702-2

Parent Item Name: Leg Clevis

Start Date: 8/07/13

Required Date: 8/09/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.250		Purchased	No			100	f	16.5400	1.225	3.8684211			
6061-T6 Bar .500 x 1.25													

Location

Loc Qty

Loc Code

MAT001

16.54

- 122521

16.54

DR/B.A 03/08/07

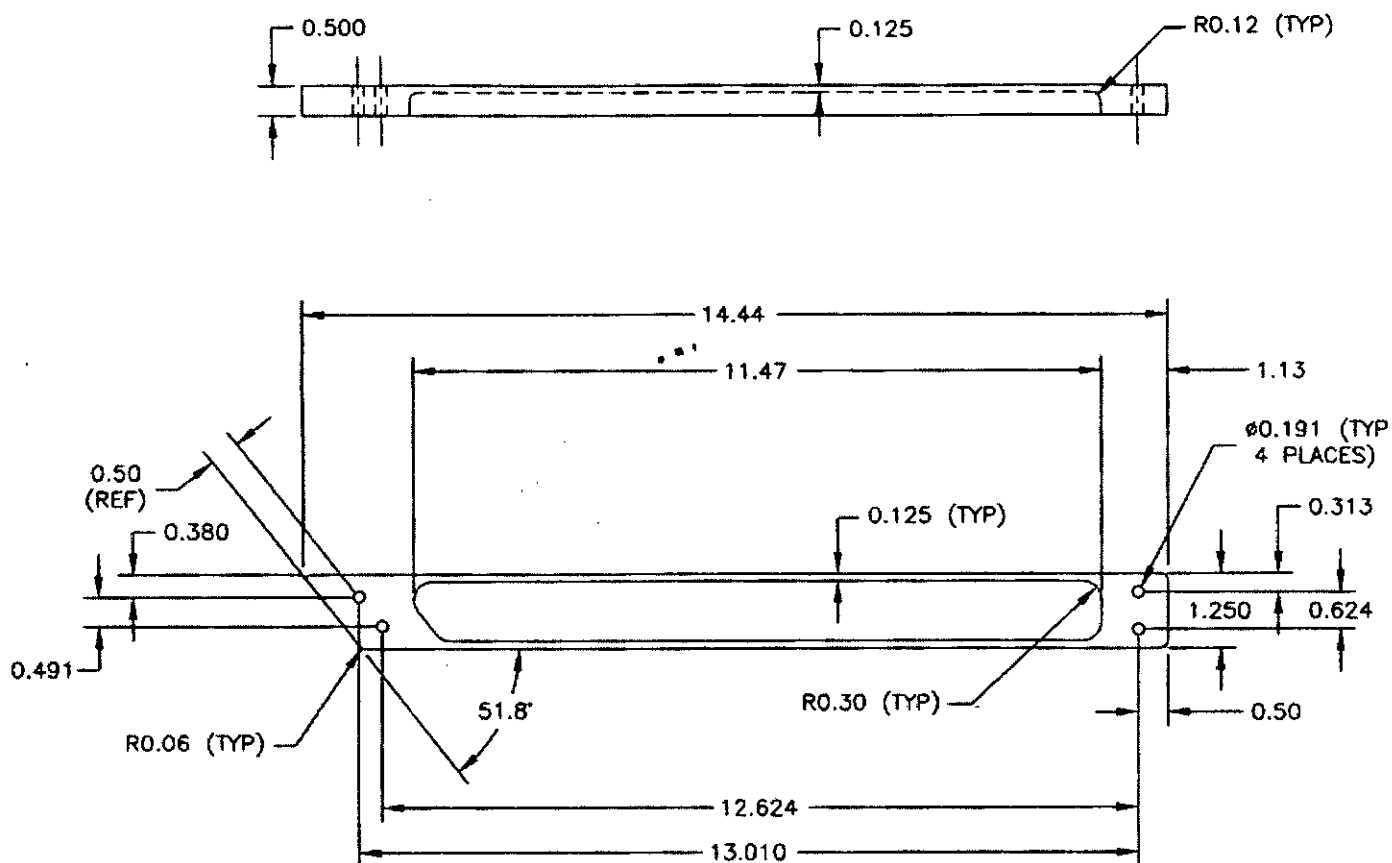
3.068

2.555

MH 13/08/08

DART**RELEASED**
99.11.02 AE

DESIGN	DRAWN BY	DART AEROSPACE LTD	
AE	AE	HAMKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED AE	DRAWING NO.	REV. B
DATE 99.10.20		D2702	SHEET 1 OF 1
		TITLE	SCALE
		STEP ARM	1:3
A	97.09.10	NEW ISSUE	
B	99.10.20	UPDATE TOLERANCE AND FINISH	



D2702-1 LEFT HAND (SHOWN)
D2702-2 RIGHT HAND (OPPOSITE)

NOTE: DEBURR ALL EDGES R0.030-R0.060
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD		Work Order:	105498
Description: Step ARM		Part Number:	2702-2
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.497	✓		MH-04	Caliper
.125	$\pm .010$.123	✓		1	1
R.12	$\pm .030$.12	✓		rad gauge	—
14.44	$\pm .030$	14.44	✓		MH-07	Tape
.50	$\pm .030$.500	✓		MH-04	Caliper
.380	$\pm .010$.383	✓		1	1
.491	$\pm .010$.491	✓		1	1
51.8°	$\pm .5°$	51.8°	✓		MH-09	angle square
13.010	$\pm .010$	13.01	✓		MH-07	tape
12.624	$\pm .010$	12.625	✓		MH-07	tape
.50	$\pm .030$.501	✓		MH-04	caliper
1.25	$\pm .010$	1.249	✓		1	1
.624	$\pm .010$.621	✓		1	1
.313	$\pm .010$.313	✓		1	1
.191 Ø	$\pm .006$ $\pm .001$.1935	✓		1	1
1.13	$\pm .030$	1.126	✓		1	1

Measured by: MH/ry	Audited by: [Signature]	Preliminary Approval:
Date: 13/08/08	Date: 13-08-14	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

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DQA:

Date: 13/08/22

QA Closed:

Date: 13/08/22

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 105 498

Part No. 2702-2

NCR No. 13-2961

DISPOSITION

Rework ☐
 Scrap ☒
 Use-as-is ☐
 Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
 Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐
 Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
 Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
	13/08/08	110	2	Part Lifted out of vise. RC Part too long for holder in 1 vise but not long enough for holding with two vises. Tool	DAS 16 8-89 05/042 13/08/09	Scrap and Destroy. replaced with mat: 122521 \$80.25	13/08/09		DAS 16 9-89 05/042 13/08/09

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

Folio/Program

☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☒ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

X